



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

ENGINEERING CHANGE NOTICE NO. 05108

SHEET 1 OF 1

DWG NO. 647.9400

REV: B

PREPARED BY: M. ANDECK

DATE: 08/20/15

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: DEFLECTORS

APPROVED BY:

ENGR

MFG

QC

EFF:

NEXT ORDER

ECR:

15-208

REASON: REVISED HOLE DIMENSIONS

TAG	X LOC	Y LOC	SIZE
A1	-8.949	-4.066	Ø .193
A2	-6.172	-3.562	Ø .193
B1	-7.903	-5.121	Ø .253
C1	-5.978	-.267	Ø .165
C2	-3.863	-.267	Ø .165
C3	-1.758	-.267	Ø .165
D1	-5.159	-2.500	Ø .250

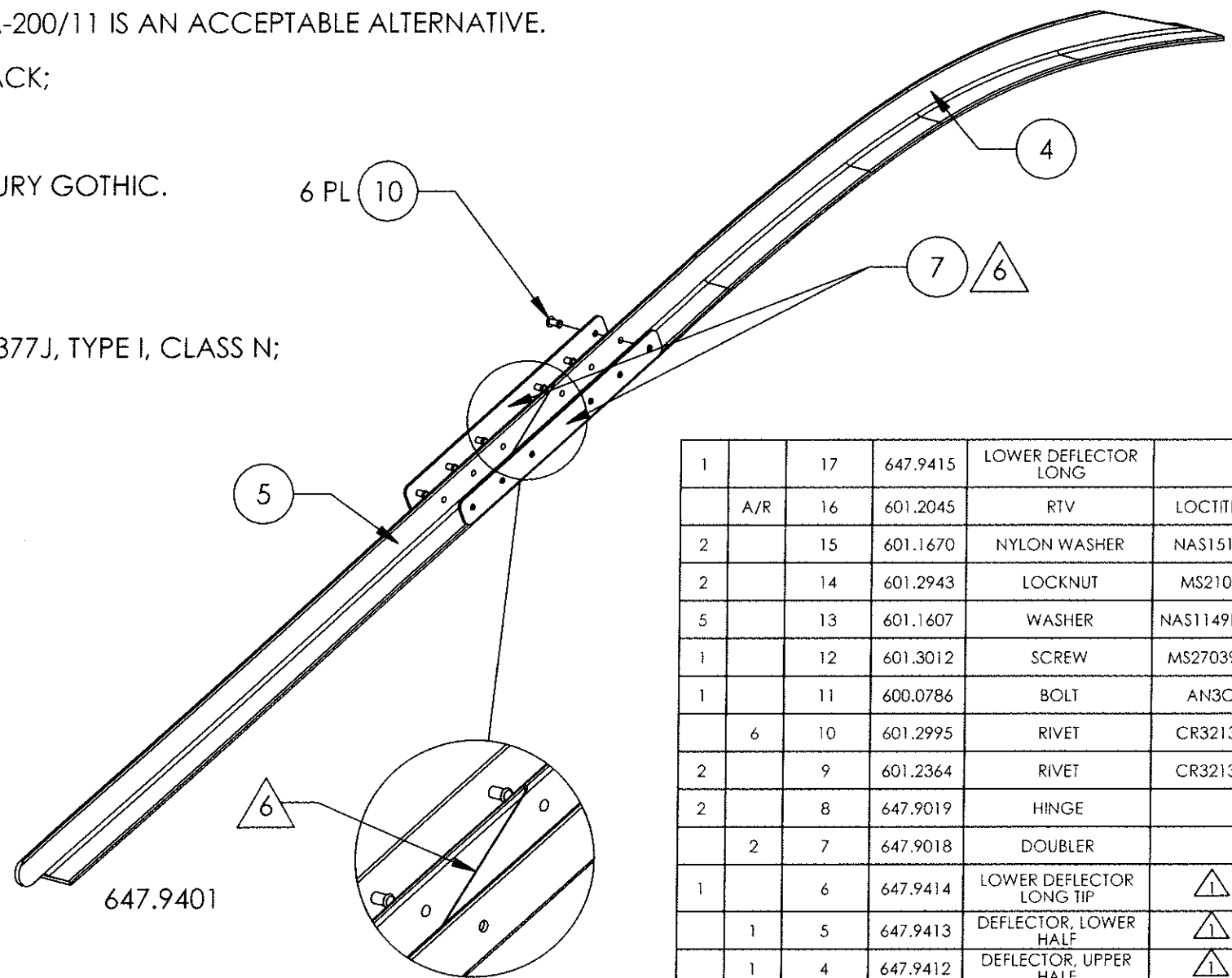
SHEET 9, ZONE C7 IS:

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION	
DOCUMENTS EFFECTED:					CHANGE CATEGORY		DER REVIEW REQUIRED
<input type="checkbox"/> PATTERN <input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRUC <input type="checkbox"/> ICA <input type="checkbox"/> BOM					<input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR		<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO

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NOTES: UNLESS OTHERWISE SPECIFIED

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12. AMS-QQ-A-200/11 IS AN ACCEPTABLE ALTERNATIVE.
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
3. DE BURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120. LASER ETCH P/N AND REVISION, 12 PT. CENTURY GOTHIC.
5. ALL DIMENSIONS SHOWN PRIOR TO FINISH.
- 6 APPLY F/N 17 TO FAYING SURFACES.
- 7 FINISH: PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J, TYPE I, CLASS N;
1-2 MIL MAX. APPLY FINISH AFTER ASSEMBLY.
- 8 TORQUE 15-20 IN.-LBS.
- 9 DIMENSION SHOWN IS FOR INSPECTION AFTER FINISHING.



UNINCORPORATED ECN(s)

05108

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
LAST PROTOTYPE RELEASE: PR1			
N/C	INITIAL RELEASE	06-09-10	P. BRAVO
A	INCORPORATE ECN 03027, 03065, 03215 & 03654.	10-23-12	J. GARDINER
B	INCORPORATE ECN 03739, 03762, 04230 & 04389.	01-28-14	P. BRAVO

1		17	647.9415	LOWER DEFLECTOR LONG		
	A/R	16	601.2045	RTV	LOCTITE 598	
2		15	601.1670	NYLON WASHER	NAS1515H3L	
2		14	601.2943	LOCKNUT	MS21042-3	
5		13	601.1607	WASHER	NAS1149F0332P	
1		12	601.3012	SCREW	MS27039-1-15	
1		11	600.0786	BOLT	AN3C7A	
	6	10	601.2995	RIVET	CR3213-6-6	
2		9	601.2364	RIVET	CR3213-4-8	
2		8	647.9019	HINGE		
	2	7	647.9018	DOUBLER		
1		6	647.9414	LOWER DEFLECTOR LONG TIP	1	2 7
	1	5	647.9413	DEFLECTOR, LOWER HALF	1	2
	1	4	647.9412	DEFLECTOR, UPPER HALF	1	2
1		3	647.9501	QUICK RELEASE PIN ASSY		
		2	647.9411	UPPER DEFLECTOR	1	2 7
		1	647.9410	LOWER DEFLECTOR	1	2 7
			647.9402	LOWER DEFLECTOR LONG ASSY		
			647.9401	DEFLECTOR ASSY		7
.9402	.9401	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.

QTY		PARTS LIST				
NEXT ASSY (S)		ORIGINAL DATE (MO-DA-YR)	06-09-10	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		
647.8900		DRAWN BY	R. ROSANO			
647.9200		CHECKER	P. BRAVO			
		DRAWING APPROVAL	P. BRAVO			
		CONTRACT No.		DEFLECTORS		
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ±.5°			SIZE B	CAGE CODE 07M26
					DWG. NO. 647.9400	REV. B
					SCALE NONE	SHEET 1 OF 9

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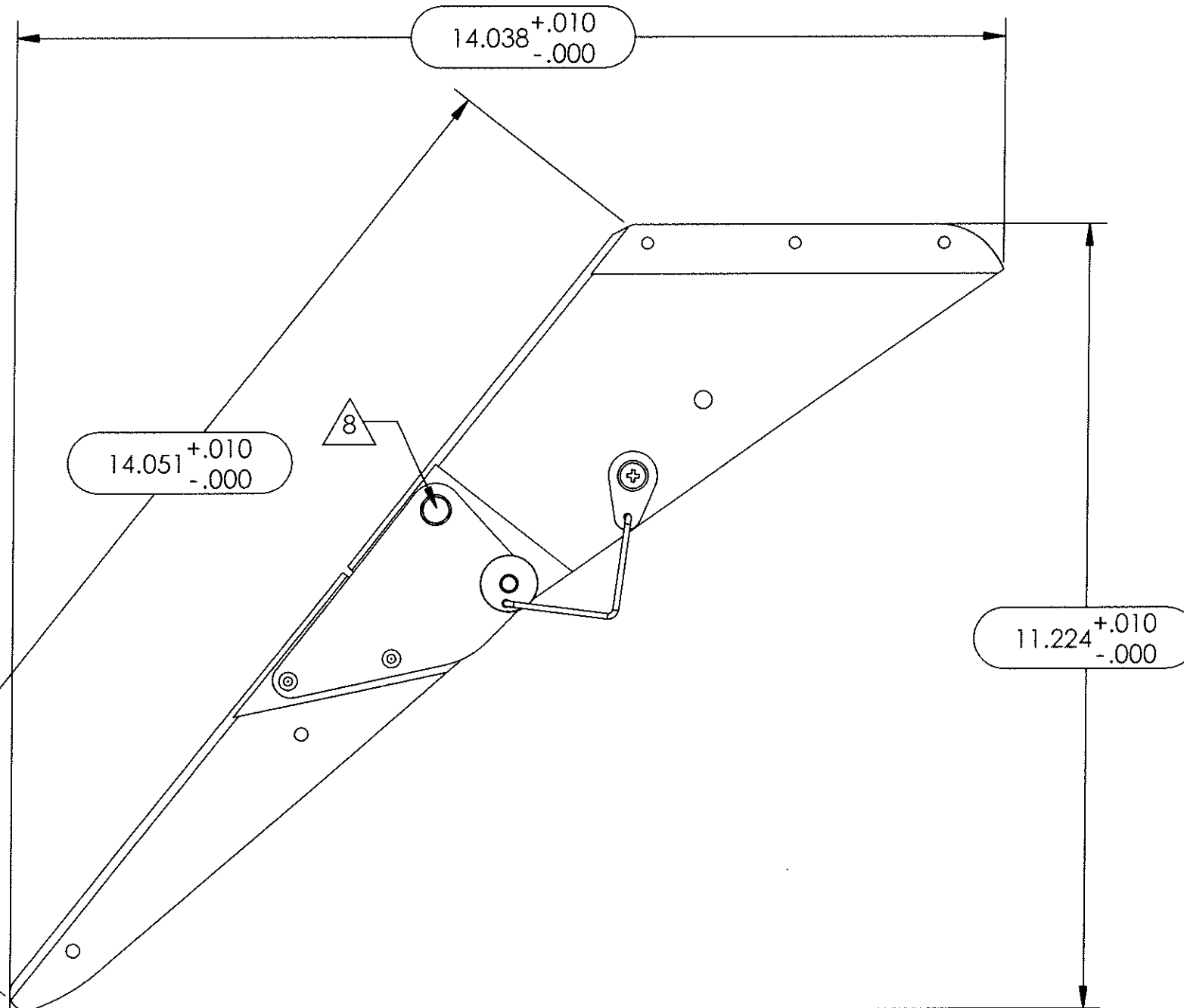
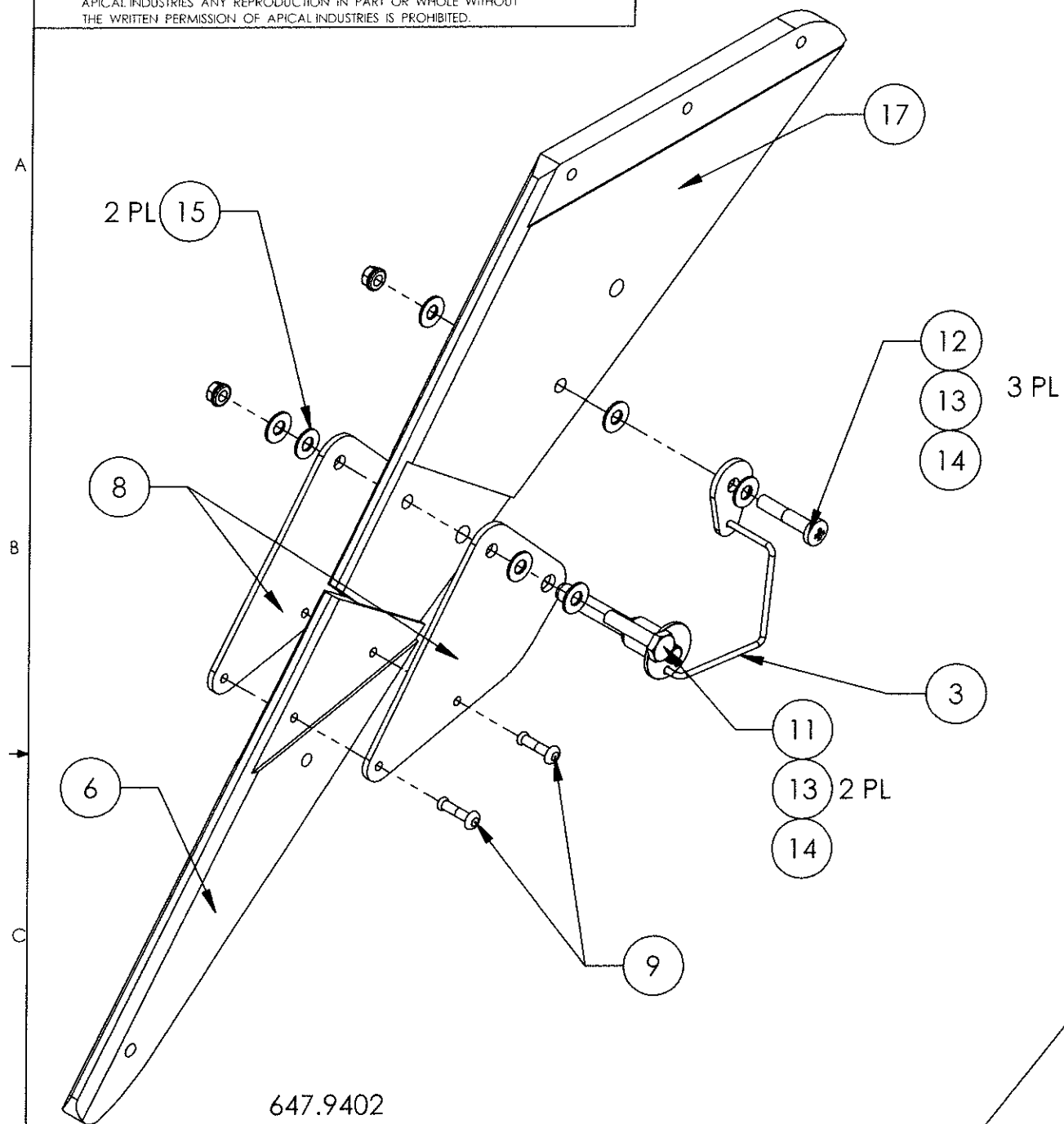
54.664^{+.010}
-.000

9.000

20.272^{+.010}
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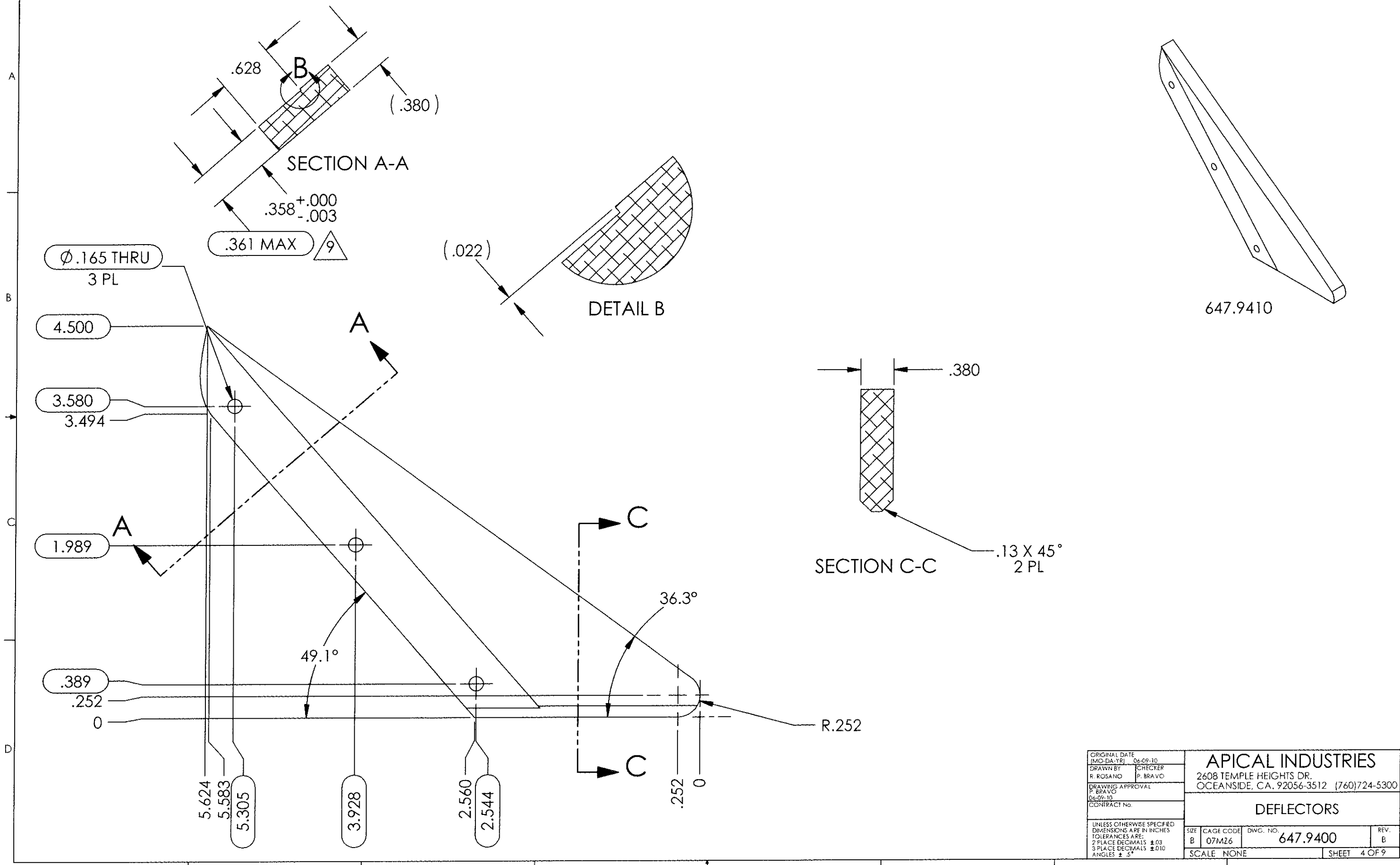
ORIGINAL DATE (MO-DA-YR) 06-09-10		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		
DRAWN BY R. ROSAHO	CHECKER P. BRAVO			
DRAWING APPROVAL P. BRAVO 06-09-10		DEFLECTORS		
CONTRACT No.		SIZE B	CAGE CODE 07MZ6	DWG. NO. 647.9400
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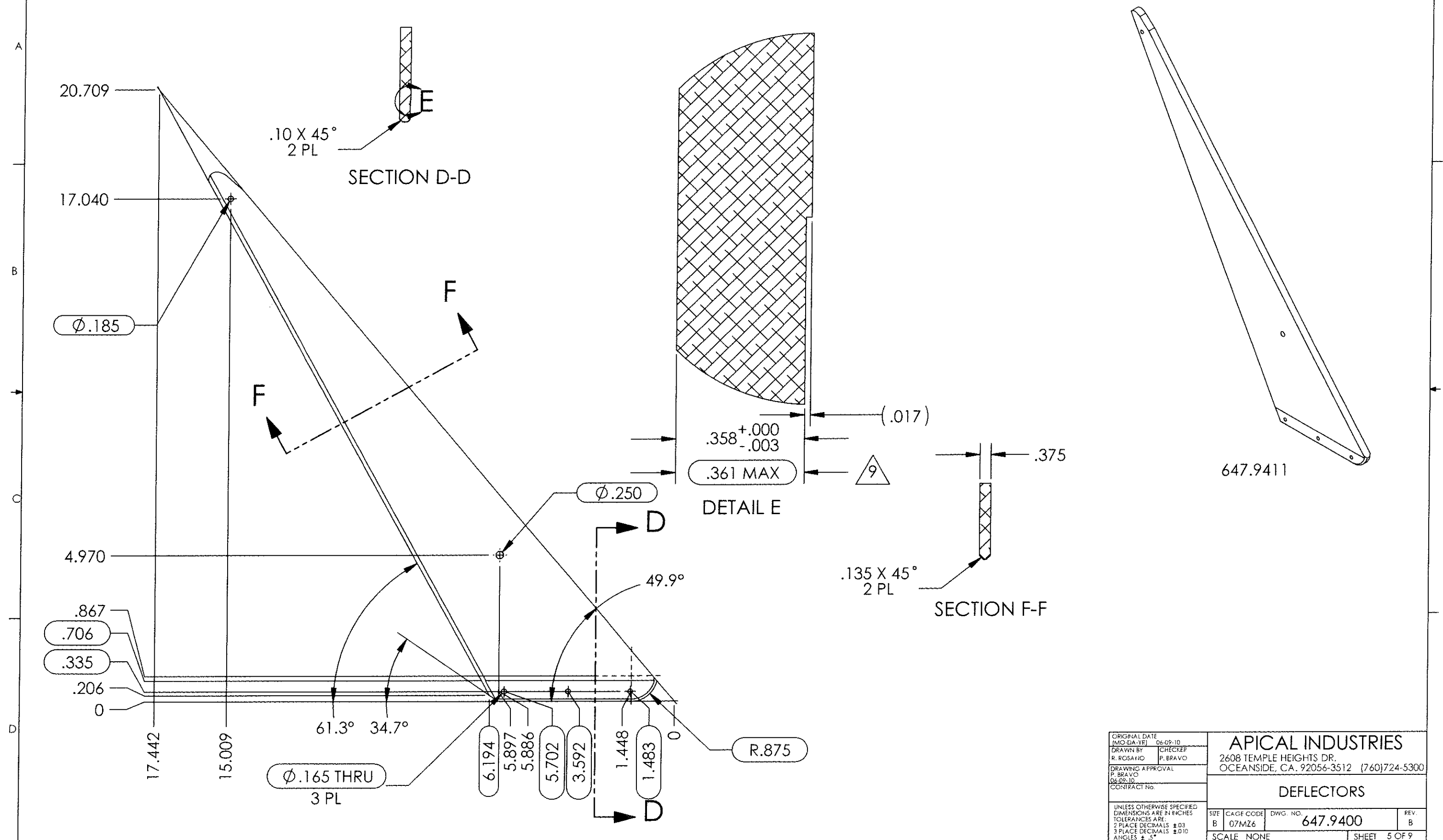


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		SCALE NONE	SHEET 3 OF 9

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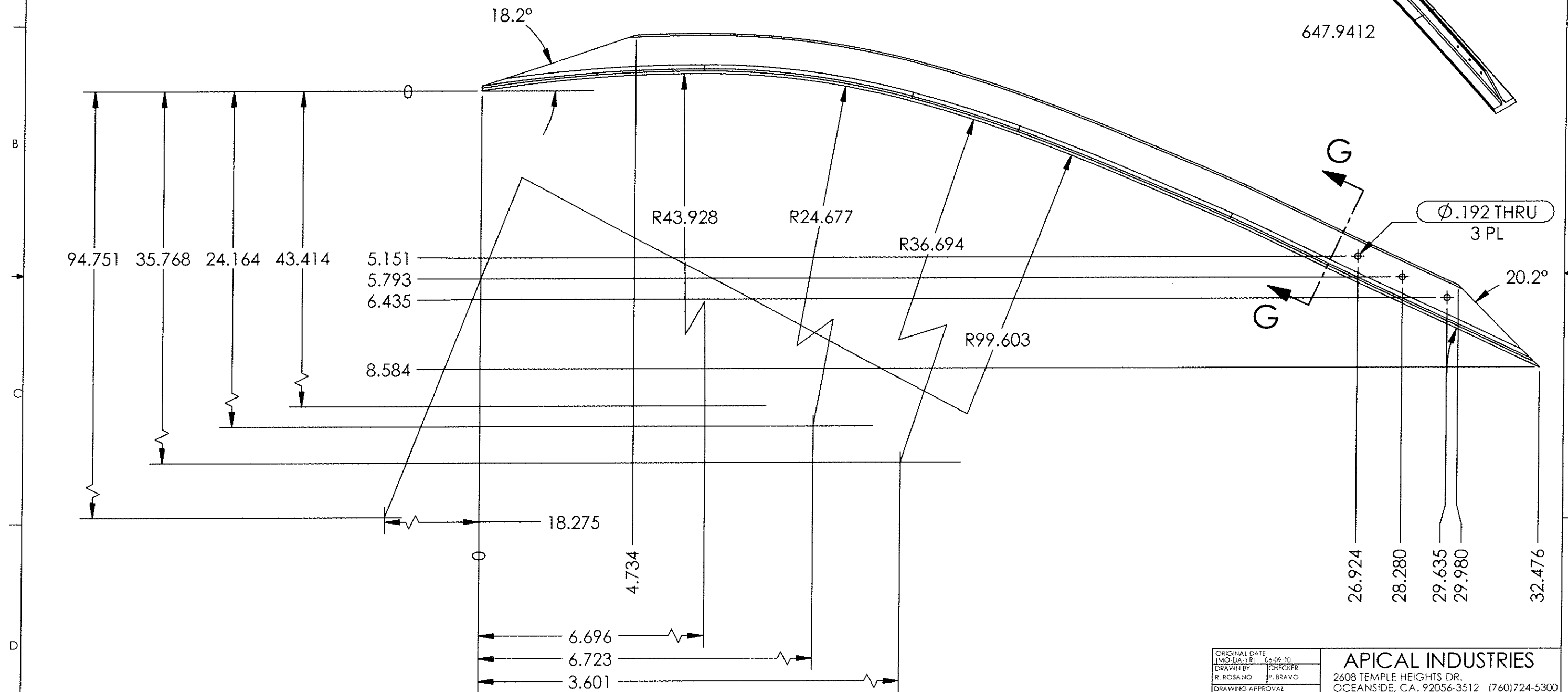
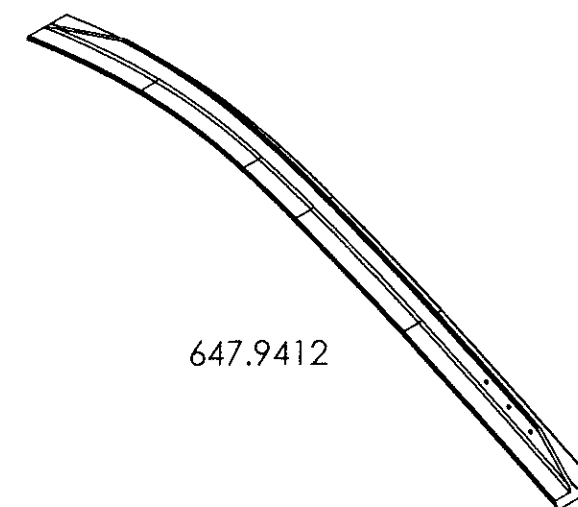
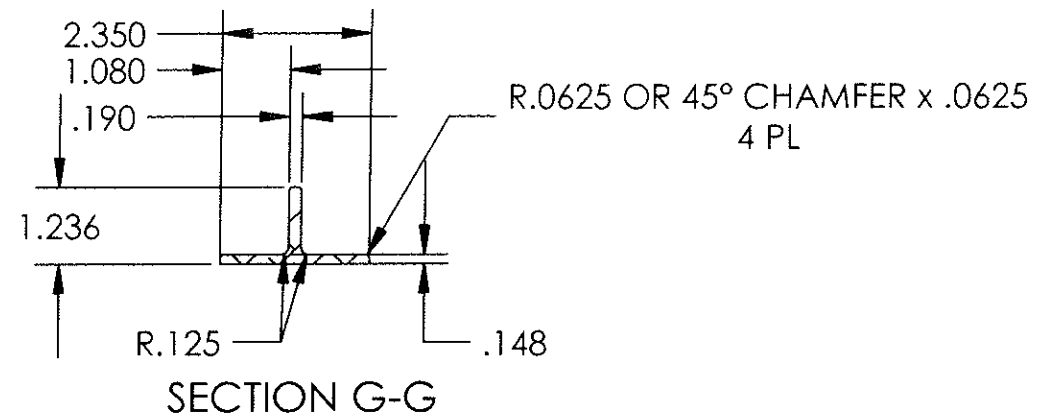


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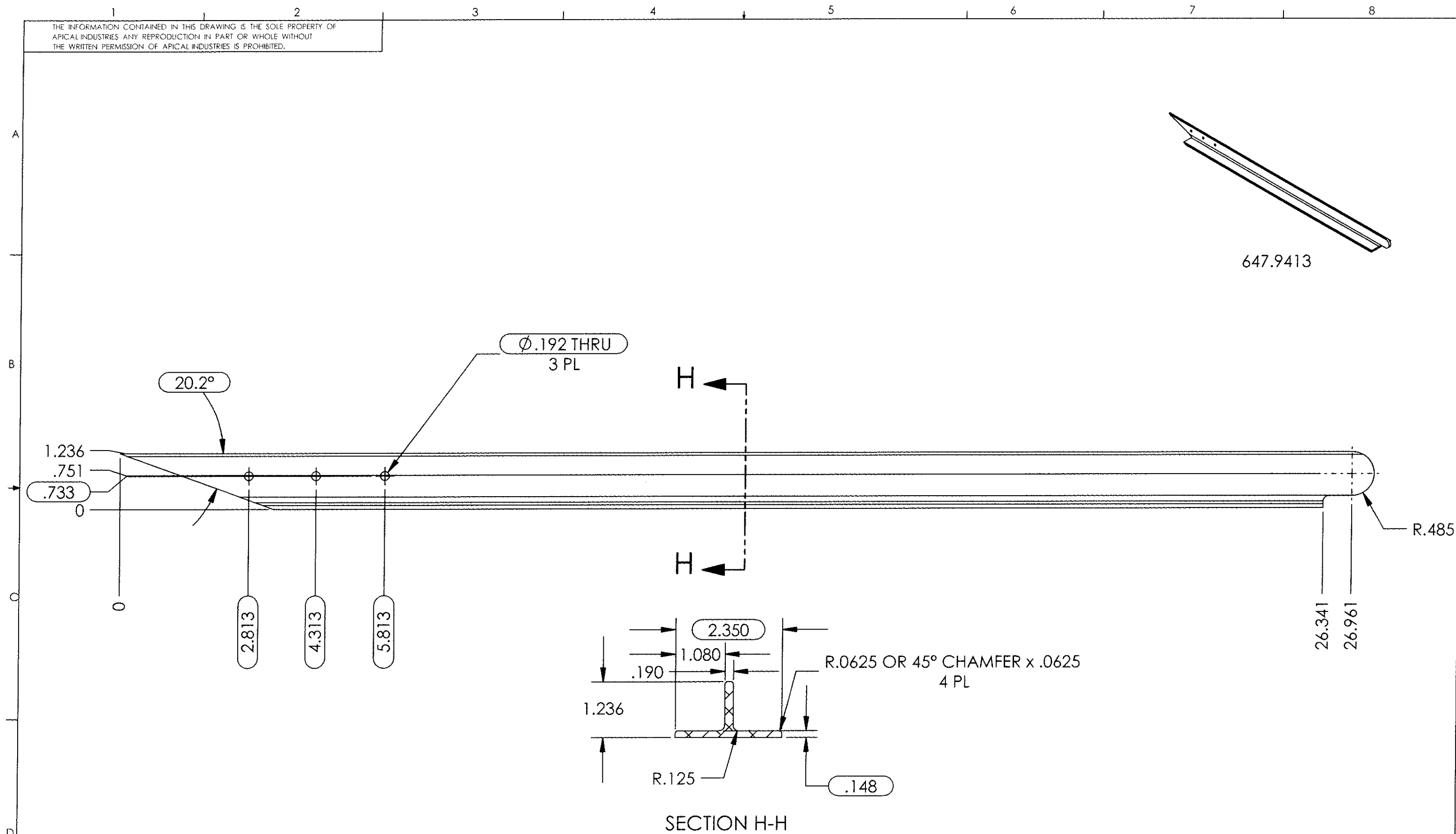
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DRAWN BY	CHECKER				
R. ROSANO	P. BRAVO				
DRAWING APPROVAL P. BRAVO		<h2 style="text-align: center;">DEFLECTORS</h2>			
06-09-10					
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		B	07M26	647.9400	B
		SCALE NONE			SHEET 5 OF 9

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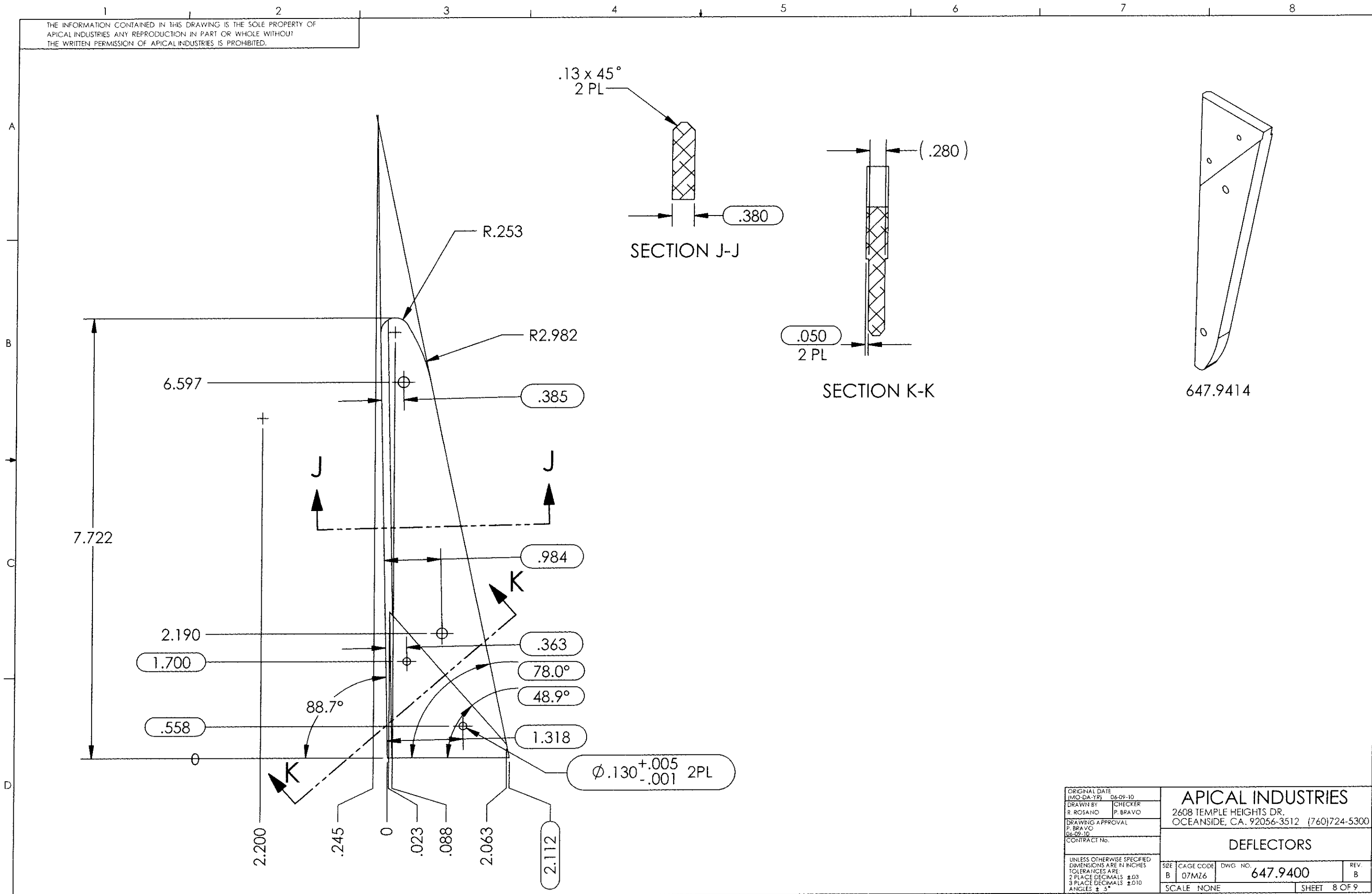
ORIGINAL DATE 06-03-1981	06-09-10	<h1>APICAL INDUSTRIES</h1> <p>2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300</p>			
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DRAWING APPROVAL P. BRAVO					
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SCALE NONE			SHEET 6 OF 9		

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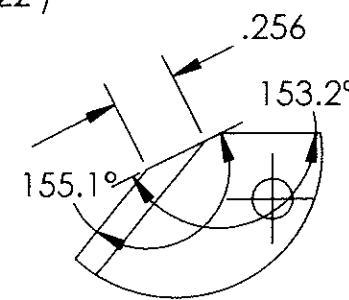
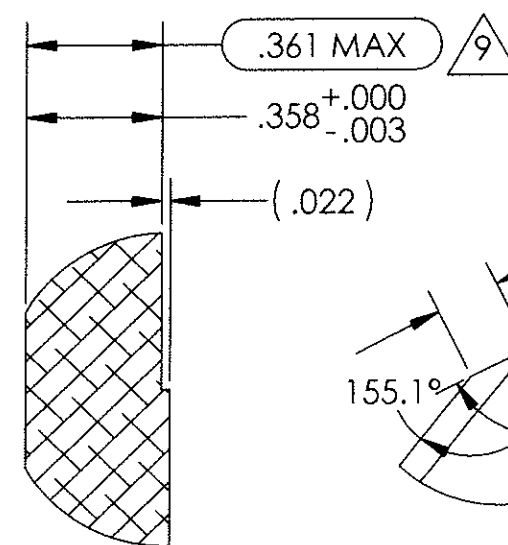
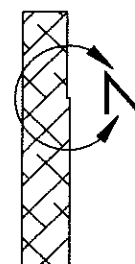
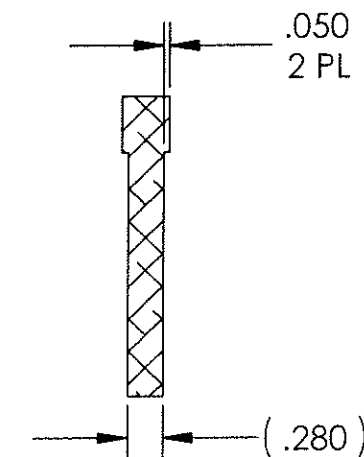
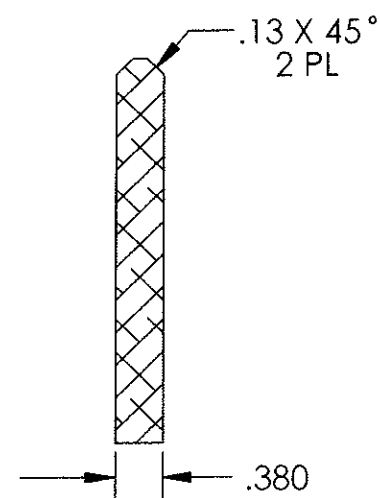
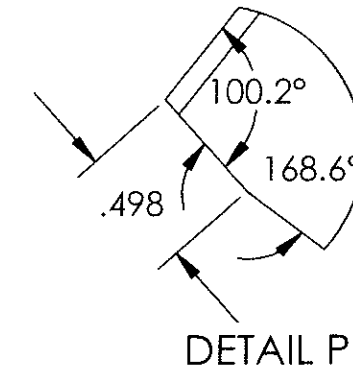
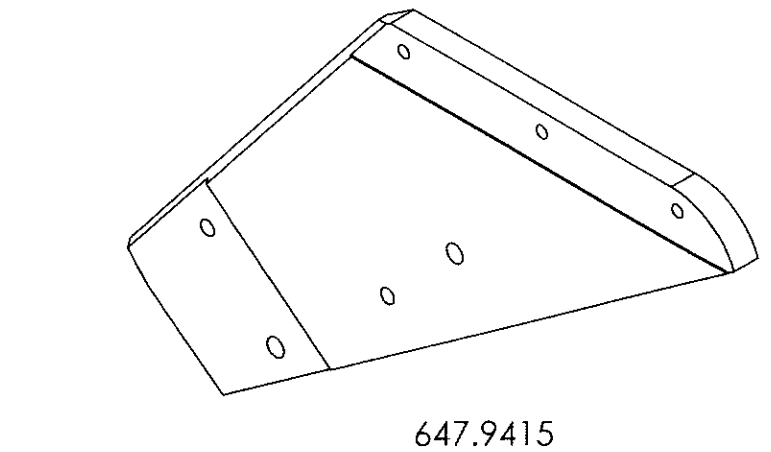
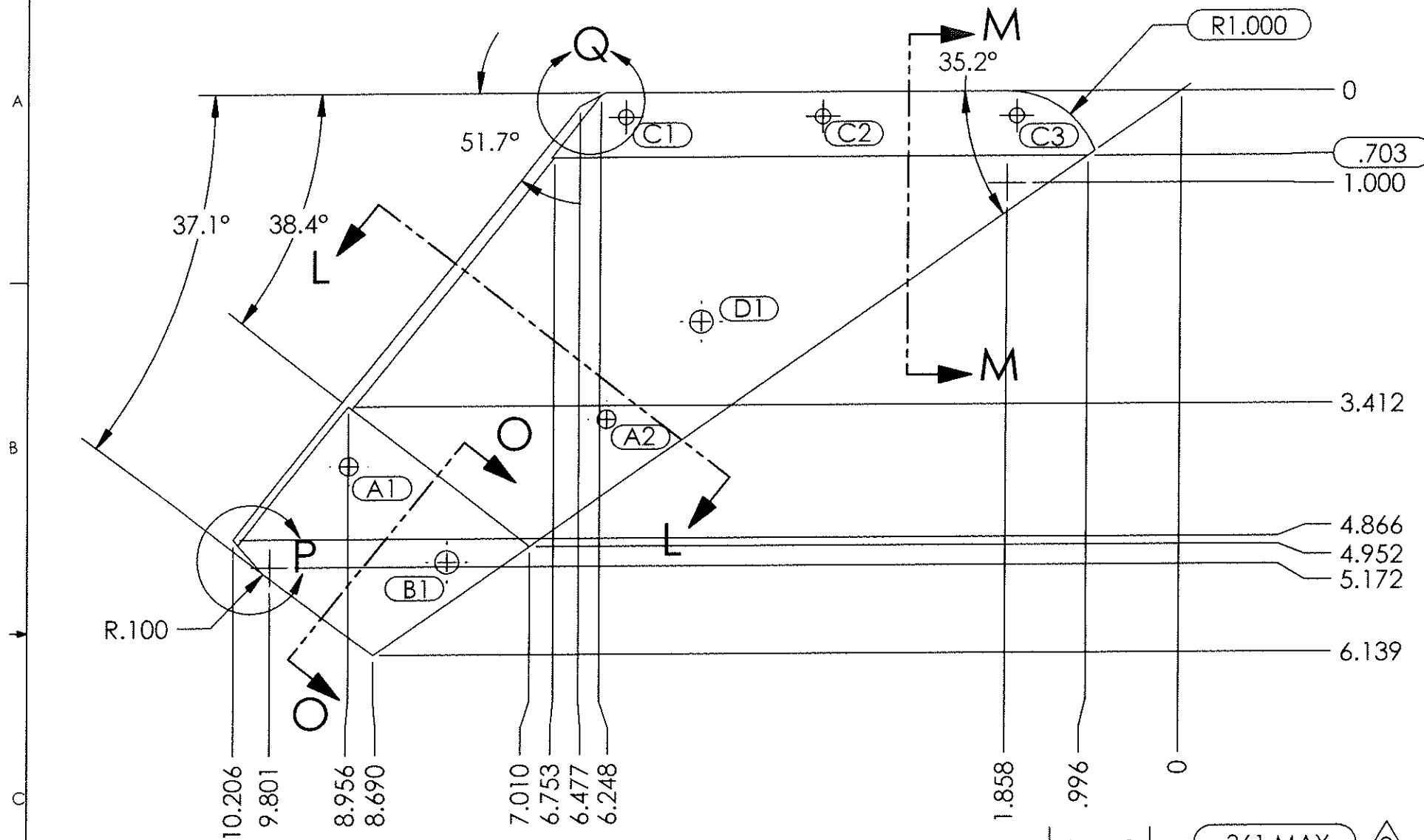
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